

Amendments to the Specification:

Please amend paragraph [0023] as follows:

Figure 6 is a cross sectional view of an oil gallery core in core number one taken along line 6-6 in Figure 4; ~~and~~

Please amend paragraph [0040] as follows:

Figure 23 is an end elevation view of a first side of core number ten;

Please amend paragraph [0047] as follows:

Referring to Figure 4, the first sand core 62 is shown to include an oil gallery sand core 100. The oil gallery sand core 100 includes a body portion 102 and anchors 104 that anchor the sand core 100 to the first sand core 62 so that the body portion 102 extends across a casting cavity 106 in which molten metal is to be poured. In the ~~illustrated core box assembly~~ exemplary embodiment shown, five oil gallery sand cores ~~100~~ are provided that are shaped differently to form oil galleries in different locations. The component parts of the oil gallery sand cores have the same reference numerals for simplicity. The oil gallery sand core 100 is provided to eliminate the need to drill an oil gallery in the finished crankshaft 10 that previously required boring with expensive rifle drills. The casting cavity 106 includes a first main bearing journal portion 110 and a first counterweight portion 112. In the exemplary embodiment shown, four bolt holes 114 are provided in which long core bolts 89 are inserted to secure the cores together to form the core box assembly 60.

Please amend paragraph [0065] as follows:

Referring to Figure 22, the other side of the ninth sand core 78 is illustrated. The portion of the casting cavity 106 defined by this side of the ninth sand core 78 ~~define~~ defines a sixth connecting rod pin portion 192 and a ninth counterweight portion 194. Cut out 124 is provided to receive an anchor 104 of the oil gallery sand core 100, as illustrated in Figure 23.

Please amend paragraph [0066] as follows:

Referring to Figure 23, one side of the tenth sand core 80 is illustrated with an oil gallery sand core 100 referred to above in connection with Figure 22. The casting cavity 106 in this side of ~~a~~ the tenth sand core ~~eight define~~ 80 defines a ninth counterweight portion 196 and a fourth main bearing journal portion 198.

Please add new paragraph [0069.1] after paragraph [0069] as follows:

One embodiment of a method for making an engine crankshaft with the metal casting core assembly can be summarized as follows. First, a suitable material like sand is coated with a resin, such as a urethane resin. Next, the resin coated sand is blown into each of the core boxes such that each core box forms an axial segment of the crankshaft. More specifically, each core box is radially split from adjacent core boxes of a core box assembly and includes a cavity that includes a portion of the desired crankshaft geometry. The resin coated sand is allowed to set in the core boxes so that it may retain the desired configuration. Setting the resin may include injecting a catalyst gas into the core boxes to set off the resin and venting the catalyst gas through a vent screed. After the sand is set, the oil gallery cores are installed in one or more of the core boxes as previously discussed. Next, the plurality of core boxes are assembled to form a core box assembly. This assembly step may include positioning a locator pin receptacle to receive a locator pin disposed on an adjacent core box as previously described. The core box assembly is secured together with one or more elongated fasteners, such as long core bolts, that extend longitudinally through the core box assembly. Next, the core box assembly is placed into a cope/drag mold. Finally, molten ductile iron is poured into the cope/drag mold and into the core box assembly to cast the crankshaft. Optionally, lightening cores and/or insert weights may be inserted into the core box assembly prior to pouring as previously discussed.